

jig, with the result that the work will frequently be sprung by the clamping device and drilled in this position, which would naturally spoil the accuracy of the location of the hole after the work was released from the jig and had expanded back to its normal shape.

It should be further borne in mind when clamping rough castings in a fixture, that they can be supported only on three points, and adjustable stops should be placed on the fourth point of the support and also under any weak portions of the piece through which holes are to be drilled or machining operations are to be performed, in order to resist the springing action of the cutter. Posts in which clamping and locating screws operate should be of liberal proportions and should not project above the fixture body any further than is necessary in order to keep down the tilting action to a minimum; and all handles for clamping devices should be so located that they will not be awkward to operate.